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D2438

Job Sheet 213268



Part No: D2438

Job Qty: 40 pcs

Part Name: Clamp



Part Weight: 0 lbs

Job Created: 9/22/20

Due Date: 10/15/20

Type: SOLD

Note: ~~DWG D2727 REV A1~~, D2438 REV C IPP: E 05.06.28 Bending removed KJ/JLM

Ship Via:

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

## Bill of Materials

## Job Routing

| Op No | Operation           | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|---------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                     |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 100   | Waterjet - Flow - 1 | 40 pcs |            | 10/14/20 | 0.17      | 1.41    | Waterjet - Flow       |           | on 20/10/20 |
|       |                     |        |            |          |           |         | Waterjet - Omax       |           |             |
| 120   | QC 8                | 40 pcs |            | 10/14/20 | 0.00      | 0.00    | QC 8 - 12             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 14             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 17             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 20             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 25             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 3              |           |             |
|       |                     |        |            |          |           |         | QC 8 - 32             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 33             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 35             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 39             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 4              |           |             |
|       |                     |        |            |          |           |         | QC 8 - 44             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 45             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 49             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 58             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 8              |           |             |
|       |                     |        |            |          |           |         | QC 8 - 9              |           |             |
|       |                     |        |            |          |           |         | QC 8 - 68             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 67             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 1 (A)          |           |             |
|       |                     |        |            |          |           |         | QC 8 - 47             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 40             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 52             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 23             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 57             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 76             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 61             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 66             |           |             |
|       |                     |        |            |          |           |         | QC 8 - 73             |           |             |

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|                                 |              |          |           |                             |             |
|---------------------------------|--------------|----------|-----------|-----------------------------|-------------|
| 130 Small Fab - 2 - B4B         | 40<br>pcs    | 10/15/20 | 0.00 1.38 | QC 8 - 82                   |             |
|                                 |              |          |           | Small Fab - 1 - B4B         |             |
|                                 |              |          |           | Small Fab - 2 - B4B         |             |
|                                 |              |          |           | Small Fab - 3 - B4B         |             |
|                                 |              |          |           | Small Fab - 4 - B4B         | OCT 06 2020 |
|                                 |              |          |           | Small Fab - 5 - B4B         |             |
|                                 |              |          |           | Small Fab - 6 - B4B         |             |
|                                 |              |          |           | Small Fab - 7 - B4B         |             |
|                                 |              |          |           | Small Fab - 8 - B4B         |             |
|                                 |              |          |           | Small Fab - 9 - B4B         |             |
|                                 |              |          |           | Small Fab - Various 1 - B4B |             |
| 140 QC 5                        | 40<br>pcs    | 10/15/20 | 0.00 0.00 | QC 5 - 10                   |             |
|                                 |              |          |           | QC 5 - 12                   |             |
|                                 |              |          |           | QC 5 - 17                   |             |
|                                 |              |          |           | QC 5 - 18                   |             |
|                                 |              |          |           | QC 5 - 19                   |             |
|                                 |              |          |           | QC 5 - 22                   |             |
|                                 |              |          |           | QC 5 - 24                   |             |
|                                 |              |          |           | QC 5 - 3                    |             |
|                                 |              |          |           | QC 5 - 43                   |             |
|                                 |              |          |           | QC 5 - 49                   |             |
|                                 |              |          |           | QC 5 - 51                   |             |
|                                 |              |          |           | QC 5 - 58                   |             |
|                                 |              |          |           | QC 5 - 68                   |             |
|                                 |              |          |           | QC 5 - 9                    |             |
|                                 |              |          |           | QC 5 - 50                   |             |
|                                 |              |          |           | QC 5 - 30                   |             |
|                                 |              |          |           | QC 5 - 40                   | OCT 07 2020 |
|                                 |              |          |           | QC 5 - 61                   |             |
|                                 |              |          |           | QC 5 - 81                   |             |
|                                 |              |          |           | QC 5 - 82                   |             |
| 150 Packaging 3-1 - Stock - B4B | 40<br>48 pcs | 10/15/20 | 0.00 0.00 | Packaging 3 - 1 - B4B       |             |
|                                 |              |          |           | Packaging 3 - 2 - B4B       |             |
|                                 |              |          |           | Packaging 3 - 3 - B4B ✓     | OCT 07 2020 |
|                                 |              |          |           | Packaging 3 - 4 - B4B       | 80          |
|                                 |              |          |           | Packaging 3 - 5 - B4B       | ST542 9-89  |
|                                 |              |          |           | Packaging 3 - 6 - B4B       |             |
|                                 |              |          |           | Packaging 3 - 7 - B4B       |             |
|                                 |              |          |           | Packaging 3 - 8 - B4B       |             |
|                                 |              |          |           | Packaging 3 - 9 - B4B       |             |
|                                 |              |          |           | Packaging 3 - 10 - B4B      |             |
|                                 |              |          |           | Packaging 3 - 11 - B4B      |             |
|                                 |              |          |           | Packaging 3 - 12 - B4B      |             |
|                                 |              |          |           | Packaging 3 - 13 - B4B      |             |
|                                 |              |          |           | Packaging 3 - 14 - B4B      |             |
|                                 |              |          |           | Packaging 3 - 15 - B4B      |             |
|                                 |              |          |           | Packaging 3 - 16 - B4B      |             |
|                                 |              |          |           | Packaging 3 - 17 - B4B      |             |
|                                 |              |          |           | Packaging 3 - 18 - B4B      |             |
|                                 |              |          |           | Packaging 3 - 19 - B4B      |             |
|                                 |              |          |           | Packaging 3 - 20 - B4B      |             |
|                                 |              |          |           | Packaging 3 - 21 - B4B      |             |
|                                 |              |          |           | Packaging 3 - 22 - B4B      |             |
|                                 |              |          |           | Packaging 3 - 23 - B4B      |             |
|                                 |              |          |           | Packaging 3 - 24 - B4B      |             |
|                                 |              |          |           | Packaging 3 - 25 - B4B      |             |
|                                 |              |          |           | Packaging 3 - 26 - B4B      |             |
|                                 |              |          |           | Packaging 3 - 27 - B4B      |             |

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|                |        |          |           |                        |      |
|----------------|--------|----------|-----------|------------------------|------|
|                |        |          |           | Packaging 3 - 28 - B4B |      |
|                |        |          |           | Packaging 3 - 29 - B4B |      |
|                |        |          |           | Packaging 3 - 30 - B4B |      |
|                |        |          |           | Packaging 3 - 31 - B4B |      |
|                |        |          |           | Packaging 3 - 32 - B4B |      |
|                |        |          |           | Packaging 3 - 33 - B4B |      |
|                |        |          |           | Packaging 3 - 34 - B4B |      |
|                |        |          |           | Packaging 3 - 35 - B4B |      |
|                |        |          |           | Packaging 3 - 36 - B4B |      |
|                |        |          |           | Packaging 3 - 37 - B4B |      |
| 160 QC 21 - SA | 40 pcs | 10/15/20 | 0.00 0.00 | QC 21 - SA - 21        | DAS  |
|                |        |          |           | QC 21 - SA - 70        | 21   |
|                |        |          |           | QC 21 - SA - 9         | 8-88 |
|                |        |          |           | QC 21 - SA - 77        |      |
|                |        |          |           | QC 21 - SA - 28        |      |

OCT 07 2020

Part Op 100 - Cut as per dwg D2438 prog rev: 24 dwg rev: 24  
 Descriptions: 120 - (QC8- Inspect parts - second check) (6.786" center to center)  
 130 - (Small Fab) 1- Use DT9713 clamp holder to hold clamp in place when forming 2- Bend as per dwg usind DT9709  
 140 - (QC5- Inspect part completeness to step on W/O)  
 150 - (Identify as per dwg & Stock Location: \_\_\_\_\_)  
 160 - QC21- Final Inspection - Work Order Release)

## Job BOM

| Part / Item | Component Name     | Quantity           | Operation               | Container |
|-------------|--------------------|--------------------|-------------------------|-----------|
| M304S16GA   | 304/316 Sheet .063 | 1.6000 sf (.04 ea) | 100-Waterjet - Flow - 1 | 5292091   |

## Job Allocations

| Operation               | Component Part | Required | Inventory | Allocated |
|-------------------------|----------------|----------|-----------|-----------|
| 100-Waterjet - Flow - 1 | M304S16GA      | 2        | 193       | 0         |

## Part Specifications

| Spec No | Description | Target/Tolerance               | Limits         | Type | Special Comments |
|---------|-------------|--------------------------------|----------------|------|------------------|
| 1       | Clamp       | 0.750inches ± 0.010            | 0.760<br>0.740 |      |                  |
| 2       | Clamp       | 6.786inches ± 0.010            | 6.796<br>6.776 |      |                  |
| 3       | Clamp       | 7.586inches ± 0.010            | 7.596<br>7.576 |      |                  |
| 4       | Clamp       | 0.063inches ± 0.010            | 0.073<br>0.053 |      |                  |
| 5       | Clamp       | 0.257inches + 0.006<br>- 0.001 | 0.263<br>0.256 |      |                  |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |



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**Container No: S304567**



**Part: D2438**

**Job No: 213268**

**Serial No/Batch: S304567**

**Revision: REV.C**

**Inspector:**

**Exp Date:**

**Instructions: Various STC's**

**Date: 10/02/20**